

Date: Monday, 11/08/2008 10:57:49 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: 206 L WEB	
<b>Job Number</b>	: 41109		<b>Part Number</b>	: D26547	
<b>Estimate Number</b>	: 10722		<b>Drawing Number</b>	: D2654 REV E1	
<b>P.O. Number</b>	:		<b>Project Number</b>	: N/A	
<b>This Issue</b>	: 11/08/2008		<b>Drawing Revision</b>	: E1	
<b>Prsht Rev.</b>	: NC		<b>Material</b>	:	
<b>First Issue</b>	: 11/08/2008		<b>Due Date</b>	: 18/08/2008	
<b>Previous Run</b>	: 40249		<b>Qty:</b>	(4) Um: Each	
<b>Written By</b>					
<b>Checked &amp; Approved By</b>	<u>JVD 08-8-11</u>				
<b>Comment</b>	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM				
	Est Rev:e 06.04.05 Added level21		EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26007140	EXT. "I BEAM" THICK	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	(4)
		Pick:	
	Qty	Part Number	Description
	1	D2600-7- 140	Web
			Batch 21966 SL 8-8-11
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Cut D2600-7 to length as per Dwg D2654	SL 8-8-11
		2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654	
		3-Using the uni-bit, open holes to finish size as per Dwg D2654	{ 08-08-12
		4-Deburr holes and ends	

3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	(8-08-12-44)
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	8-08-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 10:57:50 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 41109

Part Number: D26547

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



08/08/10

44

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Skid tube cell

RT 08-08-12

4

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Delivery

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-08-13

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

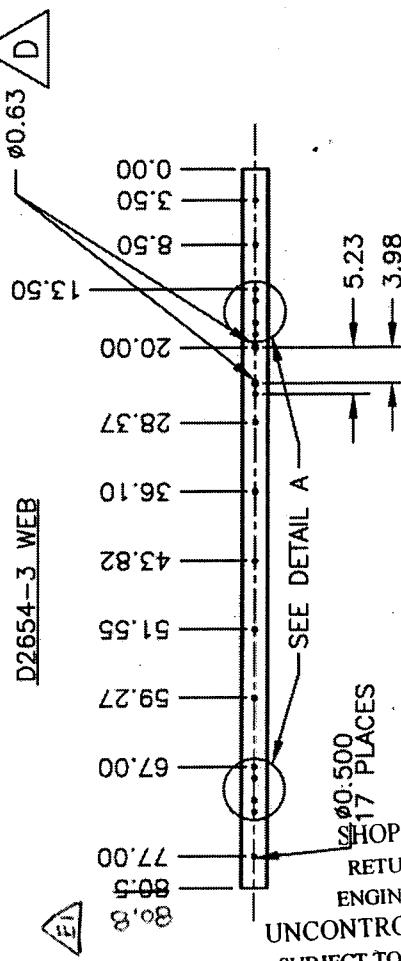
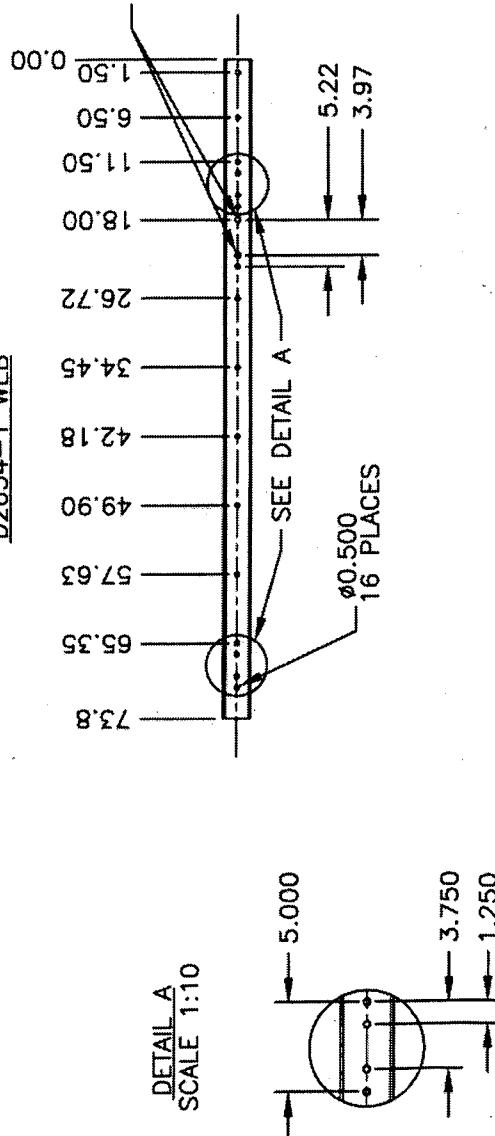
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2654	SHEET 1 OF 2
DATE		TITLE	SCALE
04.05.26		WEB	1:20

A      97.03.25    NEW ISSUE  
 B      97.06.26    ALTER HOLE PATRN., 0.500 WAS 0.438  
 C      97.10.29    CHANGED HOLE PATTERN  
 D      98.01.15    GHW HOLES CHANGED TO Ø0.63  
 E      04.05.26    CHANGE LENGTHS, REFORMAT  
 EI     04.08.04    PER TOOLING; 80.8 WAS 80.5

**RELEASED**  
 04.06.22
D2654-1 WEB

MAKE FROM D2600-5-108 EXTRUSION  
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

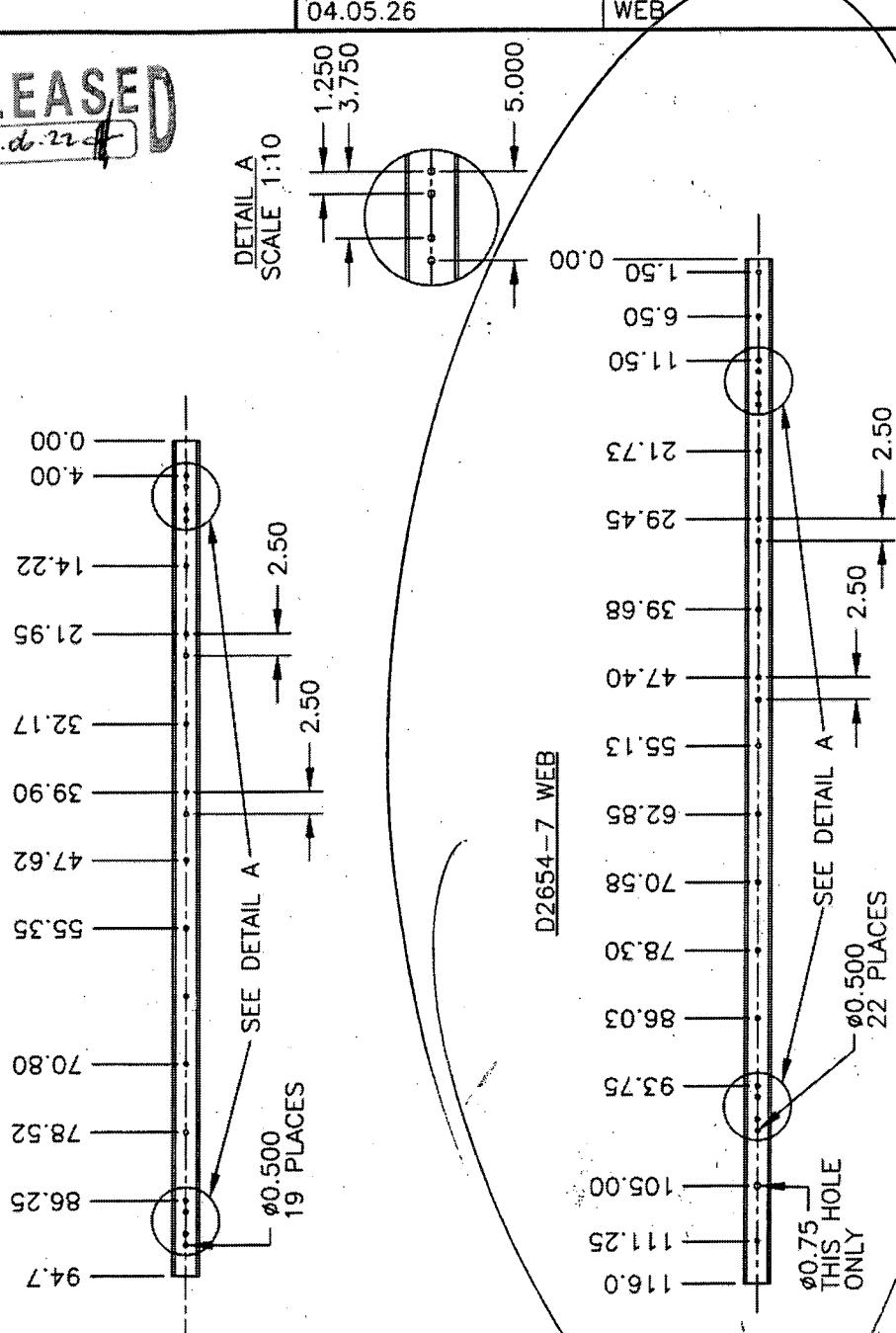
NOTE: Date & initial all entries

**DART**

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DATE		REV. E
04.05.26		SHEET 2 OF 2
		SCALE 1:20

**RELEASED**  
04.06.22

D2654-5 WEB



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MAKE FROM D2600-7-125 EXTRUSION  
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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